+Wednesday, 10/31/2007 3:26:25 PM Kim Johnston **Process Sheet** : HANDLE RIM : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 35485 : 11334 **Estimate Number** : D333019 AIU: Part Number P.O. Number S.O. No. : MA D3330 REV C **Drawing Number** : 10/31/2007 This Issue : NC : N/A Project Number Prsht Rev. : MACHINED PARTS Type **Drawing Revision** First Issue Material : 30957 Previous Run Each **Due Date** : 11/16/2007 Written By Checked & Approved By New issue KJ/JLM **6**5.01.13 : Est: Comment est В 07.05.14 rev C dwg **Additional Product** Job Number: Description: Seq. #:. 1010-1025 Steel Bar 1.0 Comment: Qty.: 0.0525 f(s)/Unit Total: 0.3150 f(s) 1010-1025 Steel Bar Material: AISI 1019 1025 1" Schedule 80 B tubing (M1025TRS80) Identify for D3330-19 HARDINGE CNC LATHE SMALL 2.0 Comment: HARDINGE CNC LATHE SMALL Turn as per Folio FA491 and Dwg D3330 Deburr 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 4.0 Comment: SECOND CHECK INSPECT WORK TO CURRENT STE 5.0 QC5

Comment: INSPECT WORK TO CURRENT STEP

Dart Aerospace Ltd

Duitho	·oopaoc							
W/O:		WORK ORDER C	HANGES					
DATE STEP		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #: Fault Category:	NCF	R: Yes	No DQ	1: <u>D</u>	Date: <u>&</u>	Mul24
		-		QA:	N/C Close	d:	_ Date: _	

	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC		Corrective Action Section B		\\\\\\		A	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
					·			
							•	
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Proval Initial Action Description Sign & Section C Chief Eng	

NOTE: Date & initial all entries

Date: Úser: Wednesday, 10/31/2007 3:26:25 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE RIM

Job Number: 35485

Part Number: D333019

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

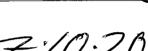
PACKAGING 1

PACKAGING RESOURCE #1

(4)

Comment: PACKAGING RESOURCE #1

Identify and Stock



7.0

QC21

FINAL INSPECTION/W/C RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W A.11.24

Dart Ae	rospace Ltd						
W/O:		WORK (ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,			
Part No	:	PAR #: Fault Category: _	NCR: Ye	s No DC	 !A:	Date:	
						Date:	
NCR:		WORK ORDER NO	ON-CONFORMANCE (NO	CR)			
	T	Corros	tive Action Coeffee D			T .	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspecto		
			1		1]				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35485
Description: Handle Rim	Part Number:	D3330-19
Inspection Dwg: D3330 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
L,		,

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	. Method of . Inspection	Comments
0.50	+/-0.030	.500		٠	!	
Ø1.31	+/-0.030	11305		. :		
Ø1.075	+/-0.030	1.305 \$1.075				
						•
100 v n						
					,, , <u></u>	
	,		-			
· · · · · · · · · · · · · · · · · · ·						
W., U.F.						
No.					A	
	11					,

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 67-11-20	Date: 07.11.20	Date:	N/A

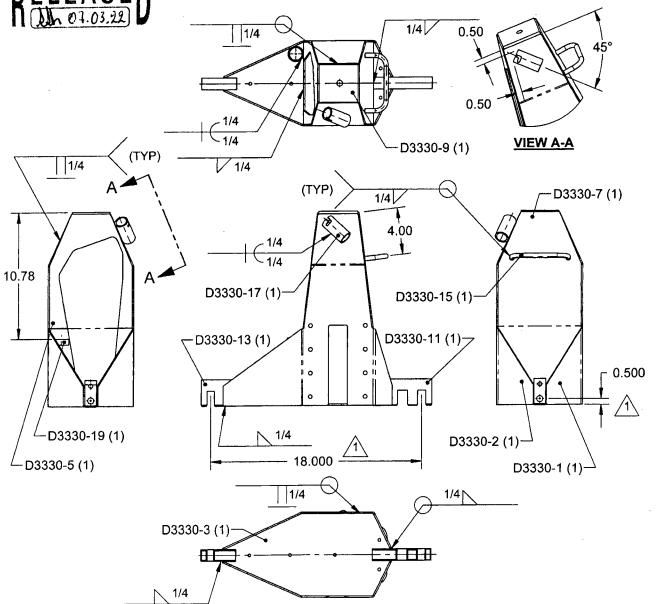
Rev	Date	Change	Revised by	Approved
Α	05.04.26	New Issue	KJ/JLM	
В	06.03.09	Dwg Rev updated	KJ/JLM ,	
С	07.05.16	Tolerance updated per Dwg Rev C	KJ/EC	E



	l			
DESIG	b	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK	(ED	APPROVED	D3330	REV. C SHEET 1 OF 9
07.03.20			FRAME WELDMENT	SCALE 1:8
 REV		DATE	DESCRIPTION	

RELEASED DA 01.03.22

-	REV	DATE	DESCRIPTION
	Α	04.12.16	NEW ISSUE
	В	05.02.26	RE-DESIGN
	С	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125



D3330-041 FRAME WELDMENT

SHOP COPY RETURN TO

ENGINEERING

1) POSITION PARTS AS PER JIG D3330-041T1

NOTES:

UNCONTROLLED COPY

2) WELD PER QSI 004

3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 433JECT TO AMENDMENT
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WITHOUT NOTICE
5) ALL DIMENSIONS ARE IN INCHES

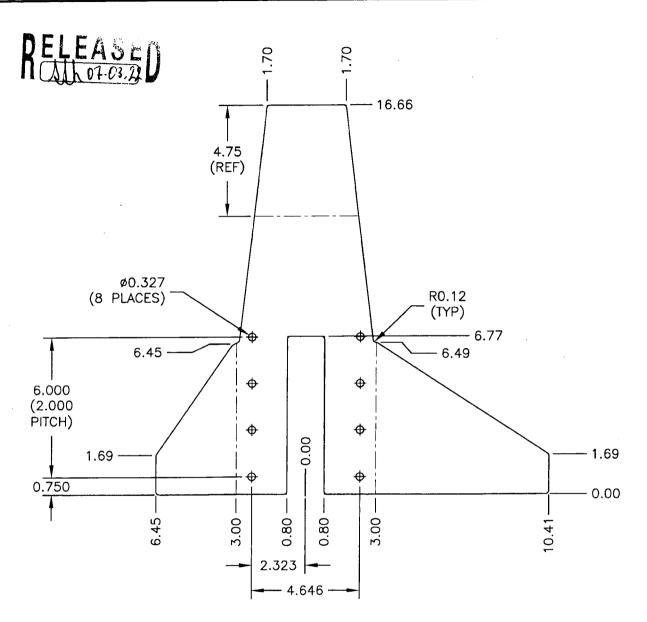
WORK ORDER

6) BREAK ALL SHARP EDGES 0.010 TO 0.020

COPYRIGHT © 2004 BY DART AEROSPACE LTD



DESIGN	DRAWN BY	DART AEROSI HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	REV. C
1 13	1 13h	D3330	SHEET 2 OF 9
DATE		TITLE	SCALE
07.03.20		FRAME WELDMENT	1:4



D3330-1 PANEL

SHOP COPY RETURN TO

ENGINEERING

NOTES:

UNCONTROLLED COPY

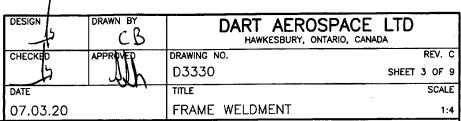
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 SUBJECT TO AMENDMENT 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) WITHOUT NOTICE

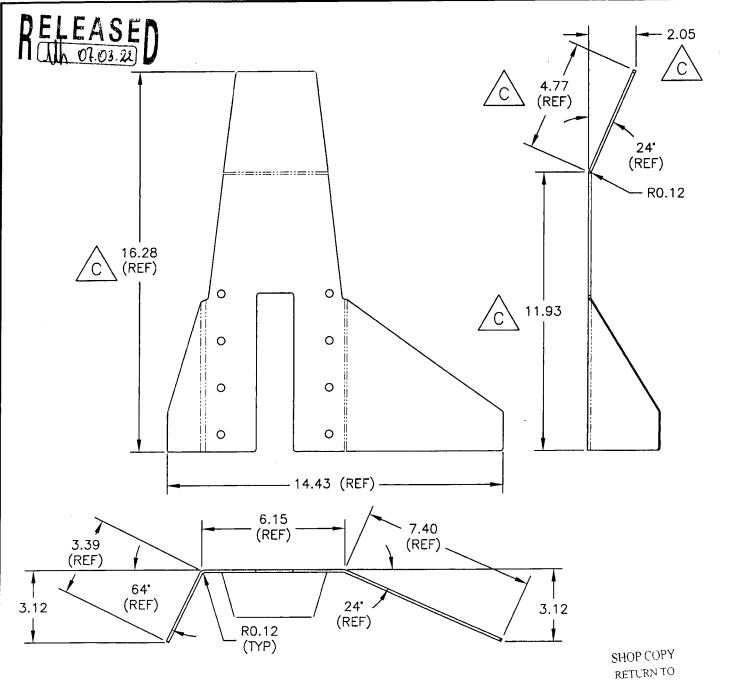
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.010







D3330-1 BEND DETAIL (SHOWN)

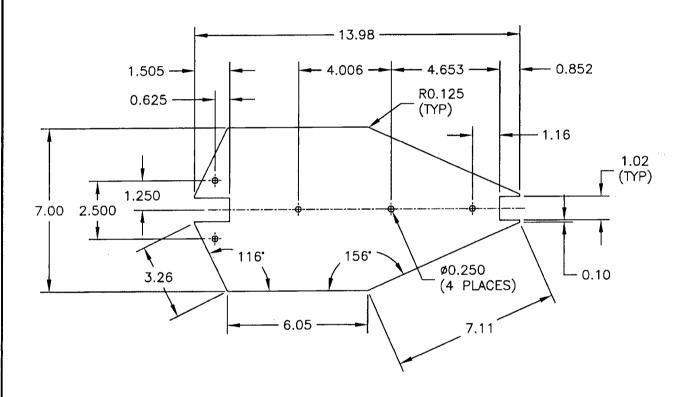
BEND D3330-2 (OPPOSITE)

ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE



 DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. C	
13	1 20h	D3330	SHEET 4 OF 9	
DATE	- A floring	TITLE	SCALE	
07.03.20		FRAME WELDMENT	1:4	

RELEASED



D3330-3 PLATE

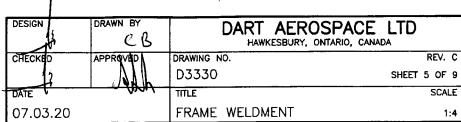
SHOP COPY RETURN TO ENGINEERING

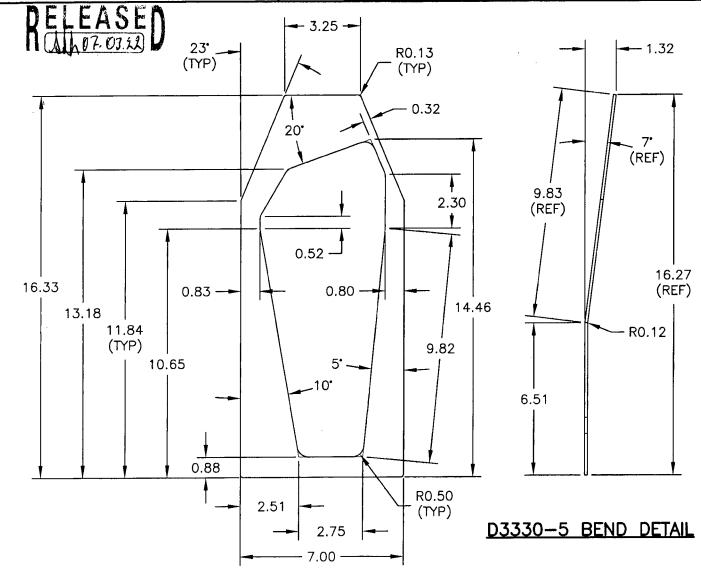
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-ENCONTROLLED COPY 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK TO AMENDMENT OF STEEL 11 GAUGE (0.125 THICK) WITHOUT NOTICE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

WORK ORDE







FLAT PATTERN

SHOP COPY

NOTES:

RETURN TO

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, ENGINEERING 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125g)和地区域 ROLLED COP
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

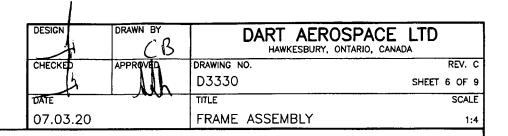
SUBJECT TO AMENDMENT

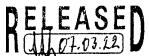
3) ALL DIMENSIONS ARE IN INCHES

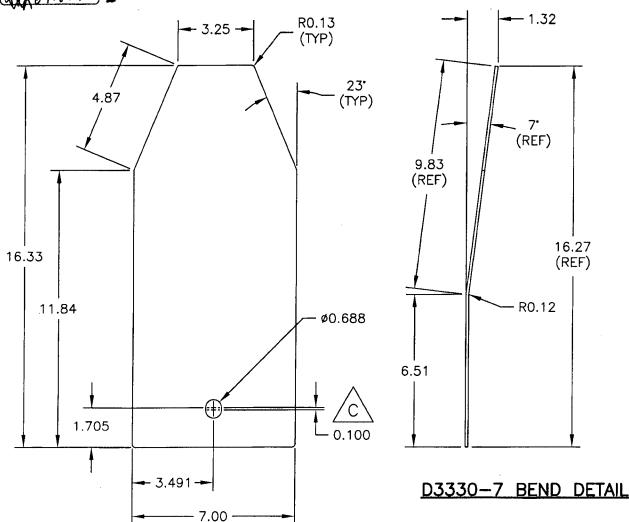
WITHOUT NOTICE

4) BREAK ALL SHARP EDGES 0.005 TO 0.010









FLAT PATTERN

NOTES:

SHOP COPY

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, RETURN TO 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) NGINEERING

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY SUBJECT TO AMENDMENT

3) ALL DIMENSIONS ARE IN INCHES4) BREAK ALL SHARP EDGES 0.005 TO 0.010

WITHOUT NOTICE

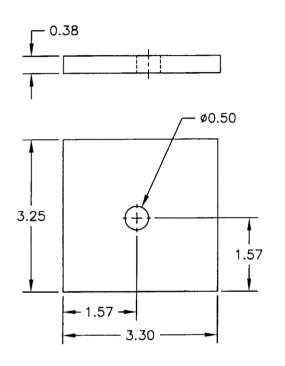
.

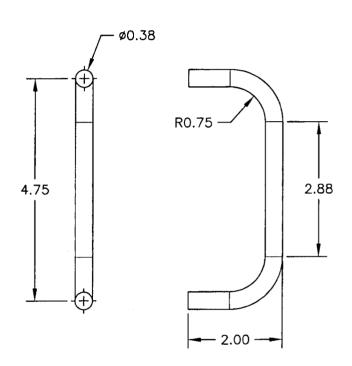
WORK ORDER

Copyright © 2004 by DART AEROSPACE LTD



DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	REV. C
1 4	Alh	D3330	SHEET 7 OF 9
DATE	1 001	TITLE	SCALE
07.03.20		FRAME WELDMENT	1:2





↑ D3330-9 TOP PLATE

NOTES:

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL

(REF. DART SPEC. M1010-B0.375x3.500)

2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY RETURN TO

ENGINEERING

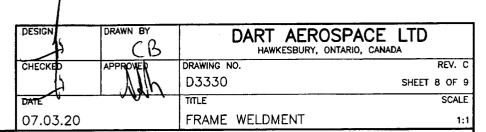
UNCONTROLLED COPY

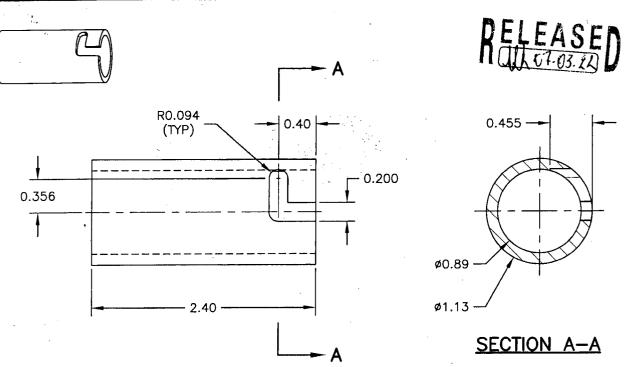
SUBJECT TO AMENDMENT

WITHOUT NOTICE

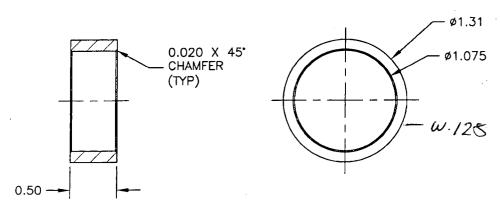
- -					
		· · · · · · · · · · · · · · · · · · ·		•	
3					
			•		
				\	
				" ;" :	
		••			
		~	•		
				*	
	V	•			
		•			
				-	
				erio de la companya	
				••	
				* (***	
				•	
					·
				With the second	
					and the second second
		·	¥.	The state of the s	







D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097

(REF. DART SPEC. M1025TR)

SHOP COPY RETURN TO

ENGINEERING

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

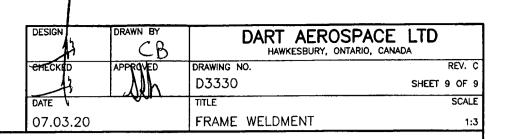
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

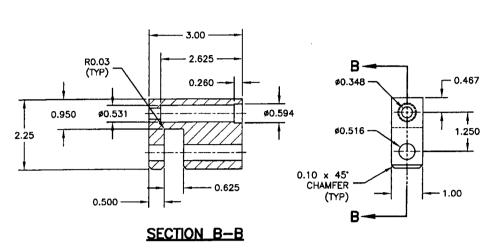
3) ALL DIMENSIONS ARE INCHES

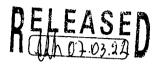
WORK ORDER

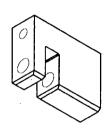
4) BREAK ALL SHARP EDGES 0.005 TO 0.010



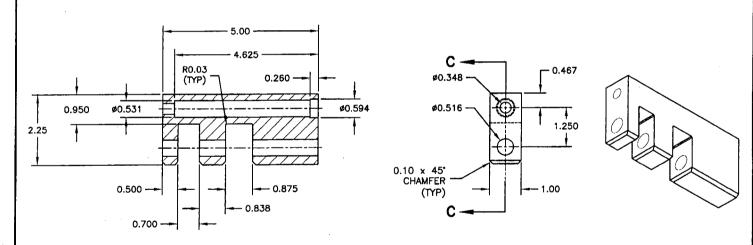








D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET

NOTES:

SHOP COPY RETURN TO

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STREDITERING (REF. DART SPEC. M1010-B1.000x02.250)

 UNCONTROLLED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

THICK STREET TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 35485

Copyright @ 2004 by DART AEROSPACE LTD